

Work Order ID 73517

Tuesday, September 20, 2011 3:55:37 PM



Page 1

Item ID: D4001-3

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 9/1/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 10.00



Customer:

DUPLICATE

Reference:

Approvals:

Process Plan:

MF

Date:

11-09-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4001-

A

100

0.00



Lathe Conv

Memo

0.00

Conventional Lathe

1-Turn as per dwg

11/09/21

9

1

DEBURR

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/09/21

9

1

PTO →

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/09/21

9

1

W/O: 73517		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D409-3 PAR #: _____ Fault Category: Machining NCR: Yes No QQA: ☒ Date: 11/09/22
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ☒ Date: 11/09/22

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/09/21	100	piece slipped out of chuck and damaged threads. Qty 1 R.C operator error. chuck was	11.09.22 GS1042	Scrap + Destroy no further	11/09/21	B.A 11/09/21		
		not tight enough. (LOA) (Drawing clear)						

NOTE: Date & initial all entries

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Required Date: 9/8/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

131

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

brush alodine as per dwg
*****do not acid etch*****

132

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

140

Identify as per dwg & Stock Location: 105

0.00



Packaging

Memo

0.00

Packaging

9 BK 11-9-22

9X & M/F 11/09/22

11/9/22 SD 90

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/9/22
MF
11-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 73517



Parent Item: D4001-3



Parent Item Name: Fitting


Start Date: 9/1/2011

Required Date: 9/8/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A 09.12.23 new issue Prelim EC verified by:DD IPP rev B
10.05.13 ecn10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN832-6D 		Purchased	No				Each	20.0000		10			

UNION



Location

Loc Qty

Loc Code

ST333

20

17909

4

118503

16

4/1
6x

Jul 11-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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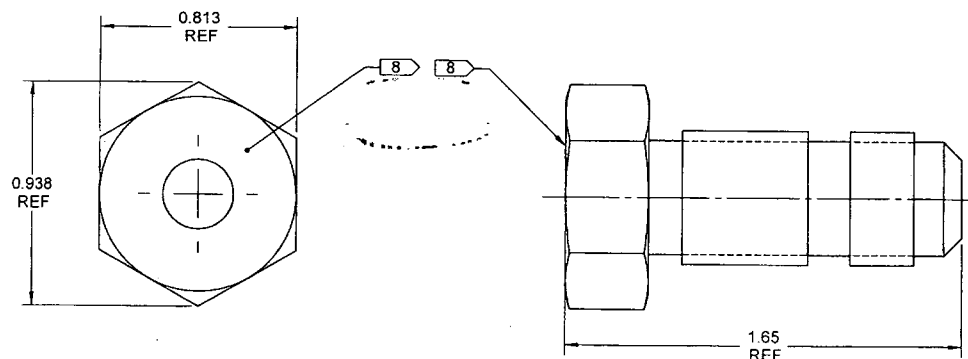
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NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-3	JCA-M47-2-28 (AN832-6D-JCA)

AN832-6D
BEFORE MODIFICATION
REF



D4001-3 FITTING

NOTES:

- 1) MATERIAL: MADE FROM AN832-6D
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4001-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs
- 8) BRUSH ALODINE MACHINED SURFACE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4001	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE FITTING	SCALE
DE APPR.			NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-05-05
MP

73517

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